

Work Order ID 74597

Monday, October 03, 2011 3:59:37 PM



Page 1

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 10/3/2011 Start Qty: 40.00



Cust Item ID:



Required Date: 10/5/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-04 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

Draw Nbr

Revision Nbr

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

304 . 063

Memo

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

0.00

0.00

0.00

S. Willoughby

120



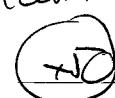
QC8- Inspect parts - second check

QC

Quality Control

Memo

(cont'd)



10-10-4



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3537-1

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Start Date: 10/3/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
Description

NC BRAKE

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Brake NC

Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 02-
Identify as D3537-1

SB 6/10/11

50

140



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

Qty Description Batch A/R 2059B Hardcoat
1119060 1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any
weld that penetrated through Wearpad if necessary

Pb →

PB/182

11-10-18

150



QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Sulwais

counts

x49

x4

Quality Control

WO: 74597 ~~74597~~

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3537-1 PAR #: 11r Fault Category: Large Part / welds NCR: Yes No DQA: No Date: 11-10-28
 11/9/18 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 11/10/31

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/10/18	#140	Qty +1 found at inspection that welder had applied too much hard coat. + carbide. Part has $\frac{1}{8}$ " (0.125") too much on weld. (Should only be 3 passes 3 weel pass on). R.C. loss + training (welder wasn't trained enough + didn't pay attention to day)	 GSE12	Scrap + Destroy no replace Qty +1 (Aesthetically not correct.)	 11-10-18	 Welds	 GSE12	 11/10/18
		RC Training	 GSE12	(RC welder was removed from part 11/10/18)	 11/10/18	 GSE12	 11/10/18	

NOTE: Date & initial all entries

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Item ID: D3537-1

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 10/3/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Sulwes

*448 of 11/10/11
cont'd*

170



Powdercoat

Powder Coating

M 118489

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

8:00 0.00

START TIME:

□ OVEN TEMPERATURE:

□ FINISH TIME:

8:30

48x 0.00 11/10/11

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

49 BR 11-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74597

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Item ID: D3537-1

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 10/3/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:	Stop	



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190



Packaging

Identify as per dwg & Stock Location: FP-2

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp49BL 11-10-19.

Packaging

Packaging

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

 11/10/19 JGMF 11-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 03, 2011 3:59:44 PM

Page 1

Work Order ID: 74597



Parent Item: D3537-1



Parent Item Name: Wearpad

Start Date: 10/3/2011

Required Date: 10/5/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased		No		100	sf	112.1300	0.106	4.463158		5.5 B11-KO-4	

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020	112.13	
118578	16.13	
118964	96	118578

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	74397
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 11-10-4	Date: 11/10/05	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	<i>[Signature]</i> <i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

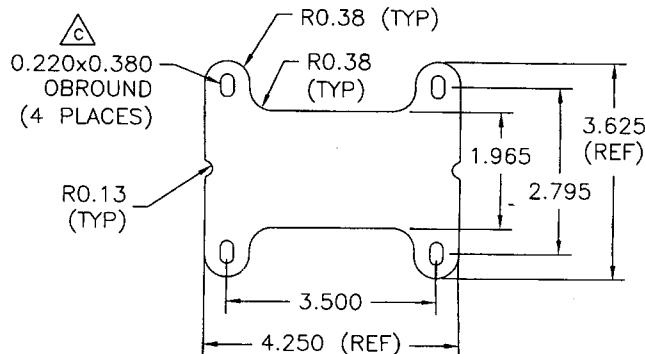
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

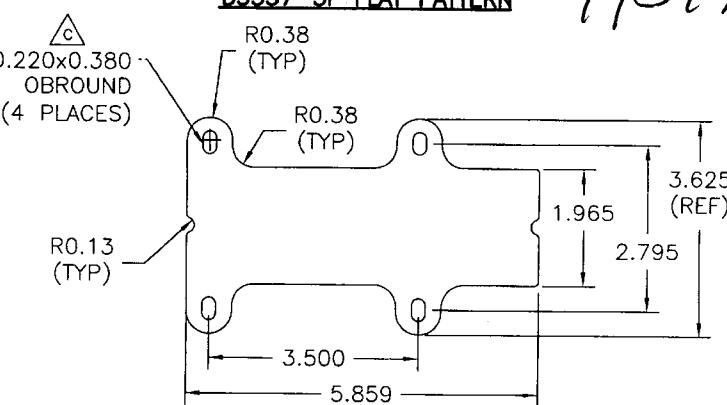
11-18-04

74591

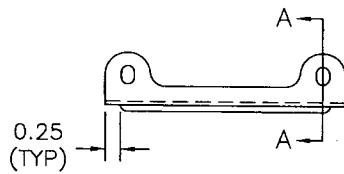
D3537-1F FLAT PATTERN



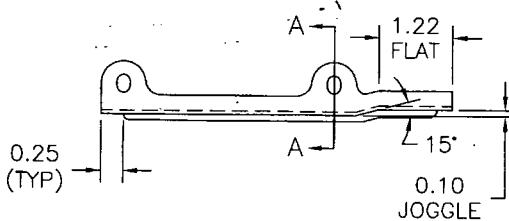
D3537-3F FLAT PATTERN



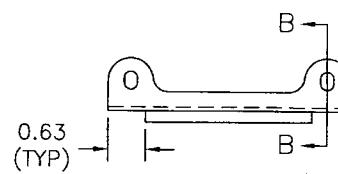
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)

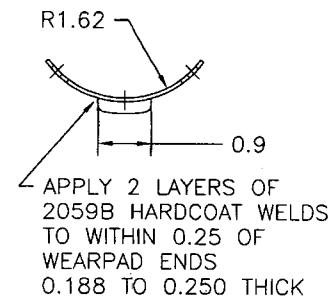


D3537-1/-3/-5/-7 WEARPAD NOTES

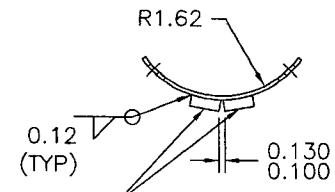
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

SECTION A-A

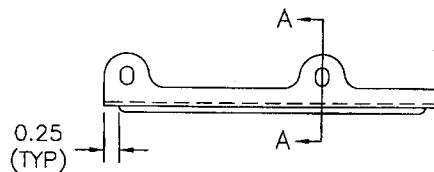


SECTION B-B



RELEASED
07.05.08 AM
per ECN
962

D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)



C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CB	PH	
CHECKED	APPROVED	DRAWING NO. D3537
DATE		REV. C SHEET 1 OF 1
07.04.13		SCALE WEARPAD

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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